

Date:
User:Monday, 5/15/2006 11:12:08 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 27115		
Estimate Number	: 11062		
P.O. Number	: N/A	Part Number	: D2934
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2934 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25378	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/30/2006
Checked & Approved By	: <u>06-05-15</u>	Qty:	40 Um: Each
Comment	: Est A 00/06.06 New Issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S080 5052-H32 .080 Sheet



Comment: Qty.: 0.0663 sf(s)/Unit Total : 2.6502 sf(s)

Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick

Batch M1100947M19380 (40)

6061-T6

*Per Eng.
(See attached Dwg)*

2.0 SHEAR SHEAR



Comment: SHEAR

1 blank makes 4 parts

Blank: 7.90" x 4.60" (+0.030" - 0.000")

N/A 06-05-19

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA072

Tumble

Deburr any rough edges after tumbling

*Water Jet.**Dwg A**Proc A**H.M 06/05/29*(40) PTO*SAD 06:05:24*(40)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06:05:24(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-05-25	3	5 parts decent out of 40. lots ^{Unit 11} delaminated in the holes due to piercing from the water jet. All parts scrap.	<i>[Signature]</i> per attached Dwg.	Scrap, destroy: replace parts with 6061-T6 .080. As per engineering approval. See Attached Dwg, & CN being released.	SAD 06-05-24	<i>[Signature]</i> 06/05/25	<i>[Signature]</i> per attached Dwg.	<i>[Signature]</i> 06-05-25

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/06/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:12:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27115

Part Number: D2934

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/05/22 * (40)

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF - 06/05/20 40

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

q.m 06-06-01 (40)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST395

AL 06/06/01 (40)

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/02 (40)

Job Completion



W 06-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

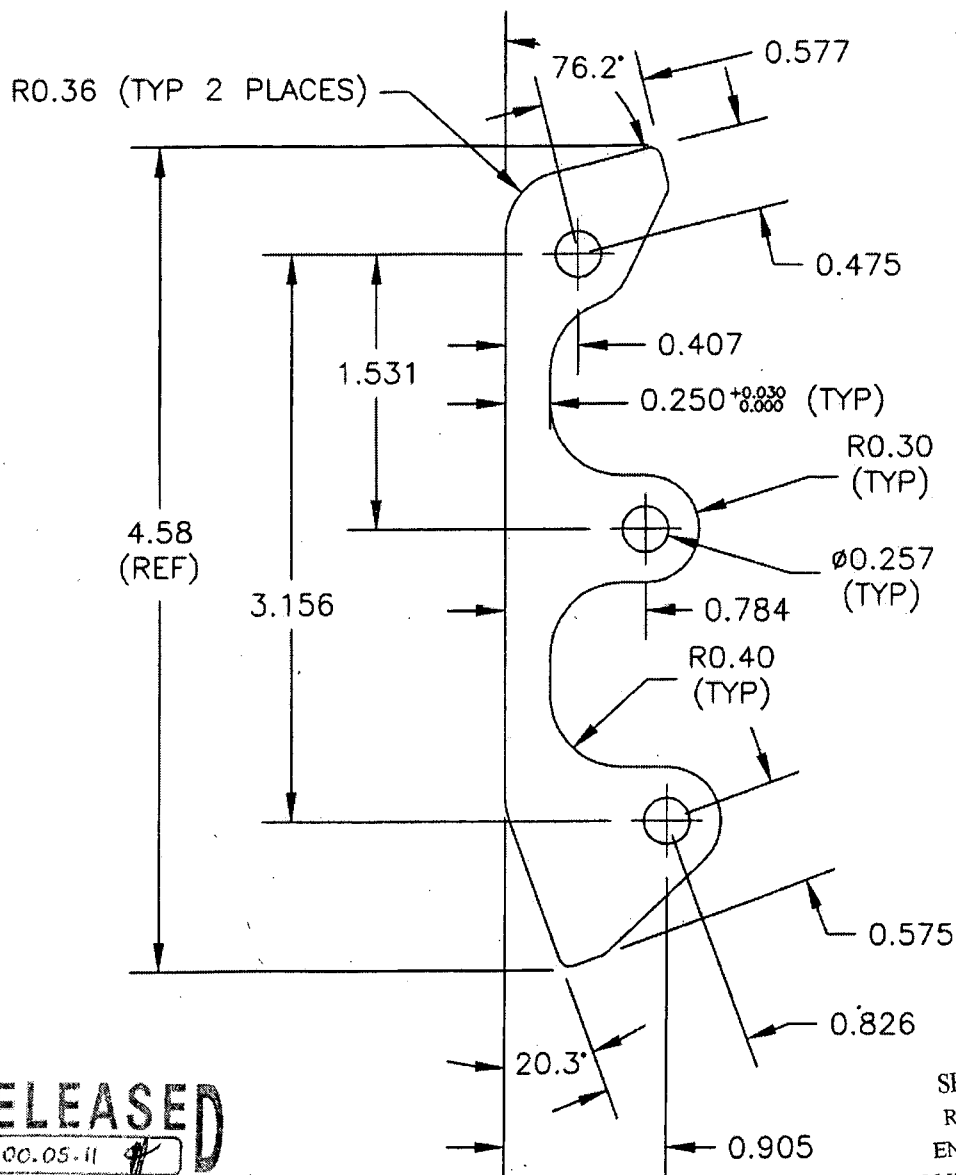
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2934	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	



RELEASED
00.05.11

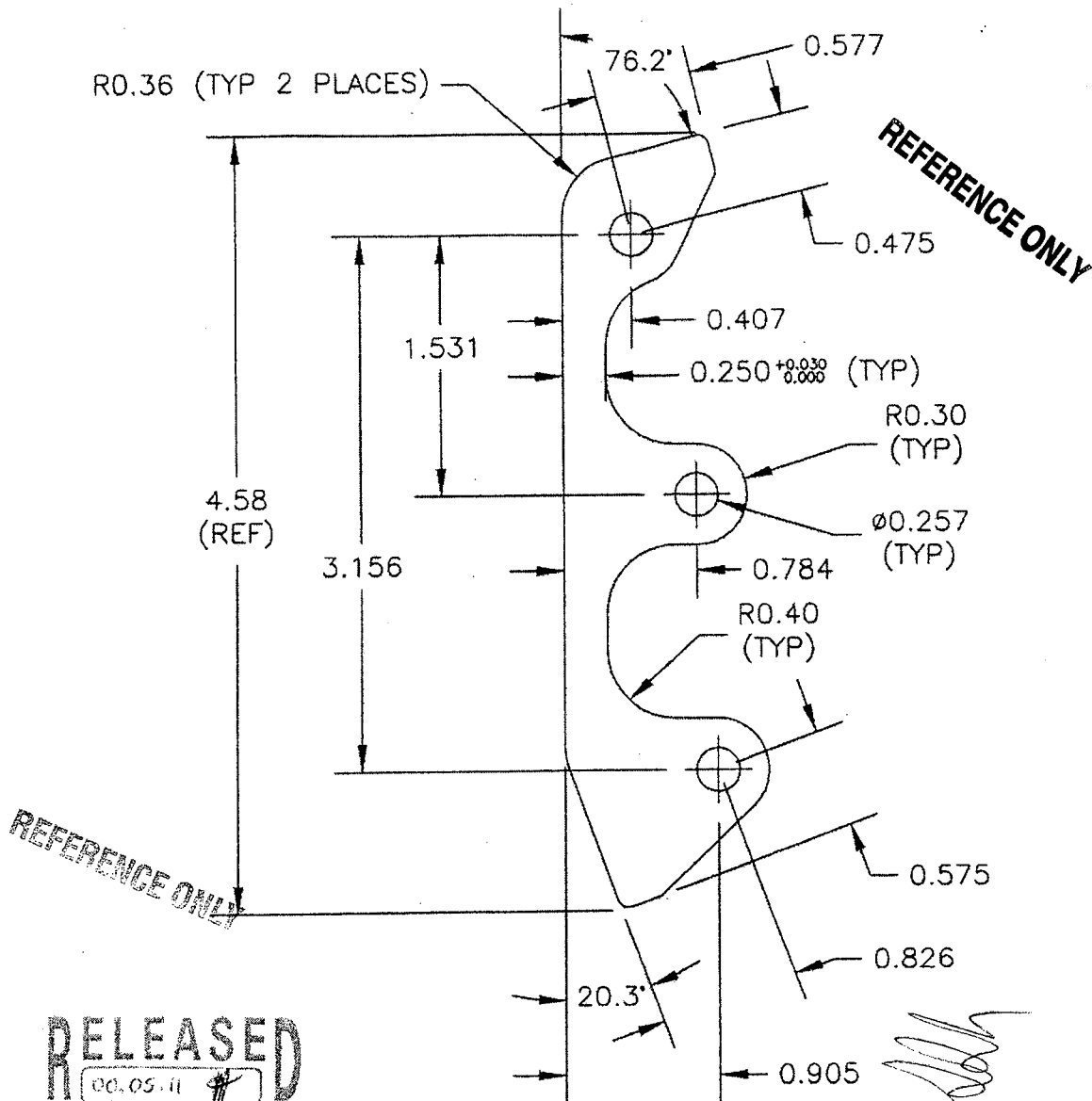
SHOP COPY
RETURN TO
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WITHOUT NOTICE

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1NO.
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORDER
27115



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2934	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	



RELEASED
00.05.11

6061-T6 (QA-A-250/11) ——— OR

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

